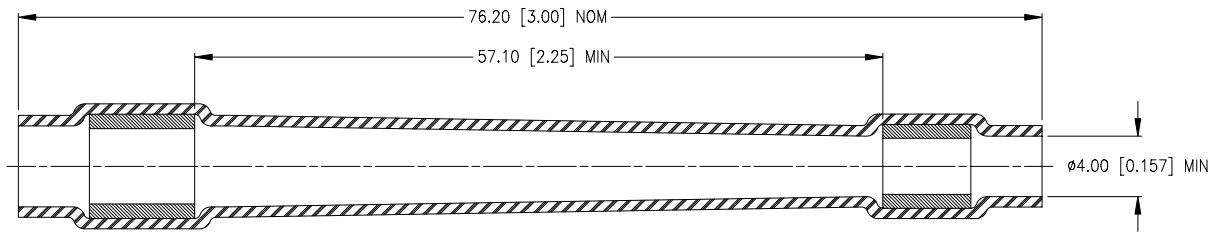
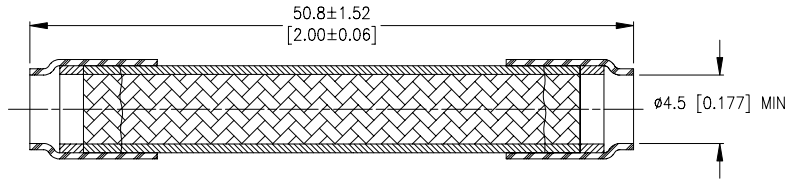


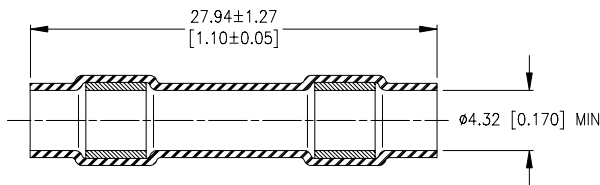
SPECIFICATION CONTROL DRAWING



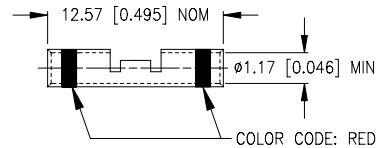
1. CABLE SEALING SLEEVE



2. FLEXIBLE SOLDERSHIELD



3. CRIMP SEALING SLEEVE



4. CRIMP

MATERIALS

1. CABLE SEALING SLEEVE:

INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.

MELTABLE RINGS: Immersion resistant thermoplastic.

2. FLEXIBLE SOLDERSHIELD:

INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.

SOLDER RING: TYPE Sn96 per ANSI/J-STD-006.

BRAID: Ni-plated copper braid. The ends shall be impregnated with Sn96 solder and coated with type ROM1 flux per ANSI/J-STD-004.

3. CRIMP SEALING SLEEVE:

INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.

MELTABLE RINGS: Immersion resistant thermoplastic.

4. CRIMP: Red stripe color code.

BASE METAL: Copper Alloy 101 or 102 per ASTM B75.

PLATING: Ni-plated per SAE AMS-QQ-N-290.

APPLICATION

- This kit is designed to provide an immersion resistant splice in 55PC6159-22 and/or 831-4877619 cables when installed as outlined herein.

Cable dimensions shall be within the range:

Conductor : 26 – 20 AWG (conductors smaller than 0.51 [0.020] in diameter must be folded back).

Jacket diameter: 2.54 to 3.94 [0.100 to 0.155]

- Temperature range: -65°C to +175°C.

 Tyco Electronics		Tyco Electronics 300 Constitution Dr Menlo Park, CA 94025, U.S.A.		TITLE: FLEXIBLE SOLDERSHIELD SPLICE KIT NI-PLATED SHIELD		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]		Raychem		DOCUMENT NO.: D-150-0318-NF		
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		REV: B	DATE: 16-Apr-07	
DRAWN BY: P.TALLY	CAGE CODE: 06090	REPLACES: D050028	ECO NUMBER: 07-008954	SCALE: NTS	SIZE: A	SHEET: 1 of 3

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SPECIFICATION CONTROL DRAWING

D-150-0318-NF

INSTALLATION PROCEDURE

A. Application Equipment:

a) Heating tools:

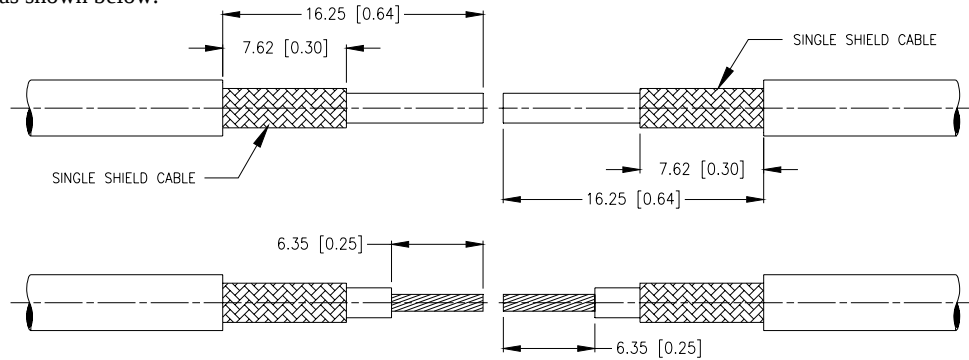
AA-400	Super heater with soldersleeve reflector
CV-5300	Mini-gun with MG-1 soldersleeve reflector
CV-4505	Shop air heater with soldersleeve tip
500 A	Thermogun with TG-14A reflector
HL1802E	Steinel Hot-air heater with PR25 soldersleeve reflector

b) Crimp tool:

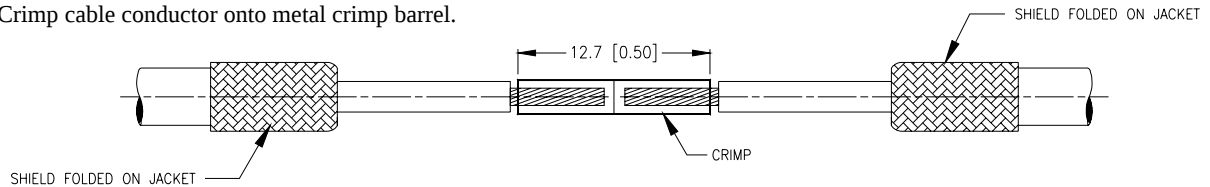
AD-1377 Crimp Tool or equivalent

B: For Single Shield Cable to Single Shield Cable Splice.

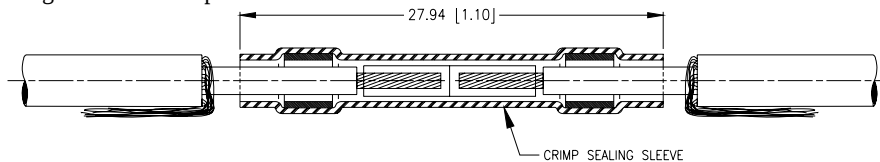
1. Place the Cable Sealing Sleeve, Flexible SolderShield and Crimp Sealing Sleeve on the cable attached to connector.
2. Strip cables as shown below.



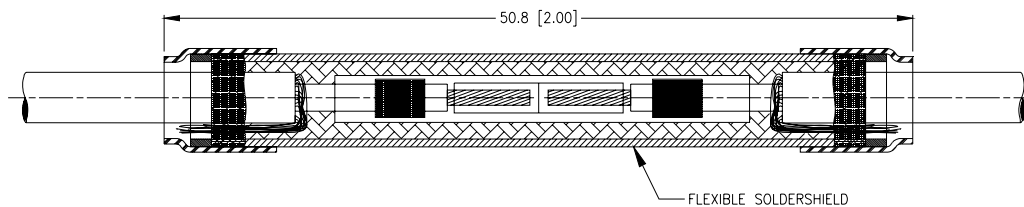
3. Crimp cable conductor onto metal crimp barrel.



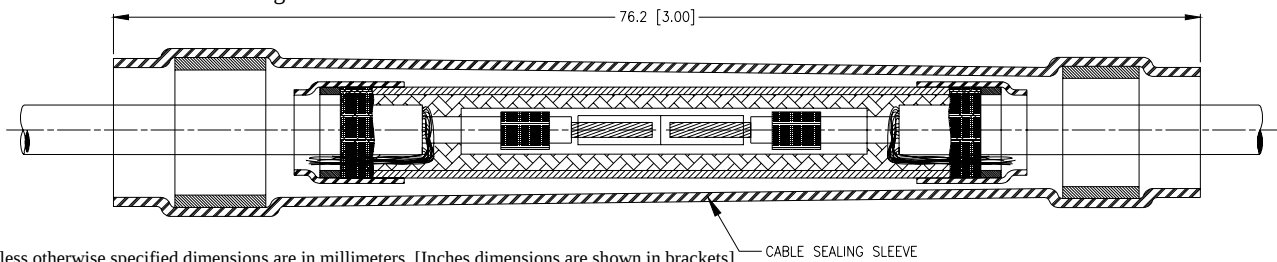
4. Install Crimp Sealing Sleeve on crimp barrel.



5. Fold the shields back with all strands grouped together.
6. Install the Flexible SolderShield as shown.



7. Install the Cable Sealing Sleeve as shown.



Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]

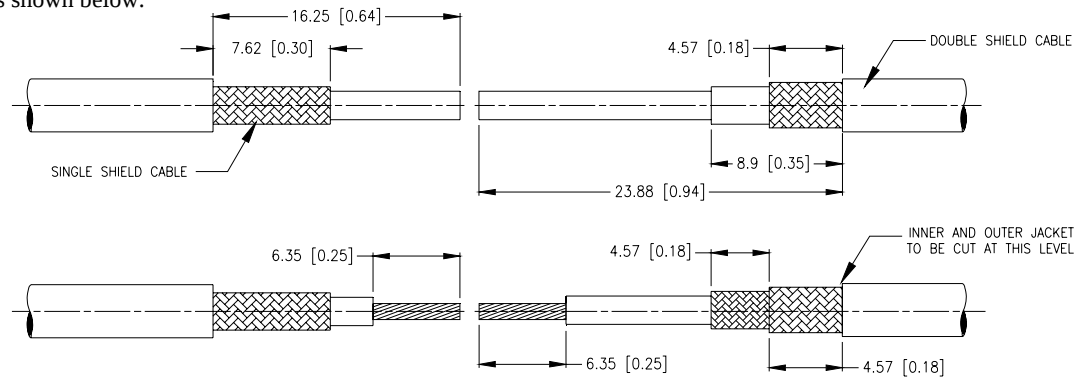
DOCUMENT NO.: D-150-0318-NF	REV: B	ECO NUMBER: 07-008954	DATE: 16-Apr-07	SHEET: 2 of 3
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SPECIFICATION CONTROL DRAWING

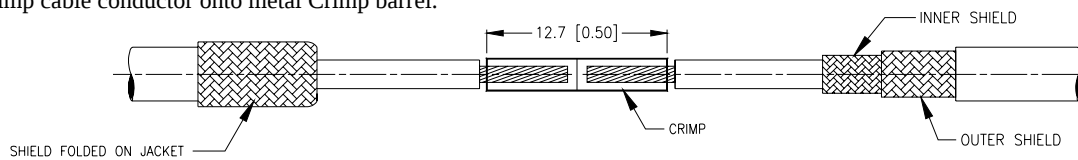
D-150-0318-NF

C: For Single Shield Cable to Double Shield Cable Splice.

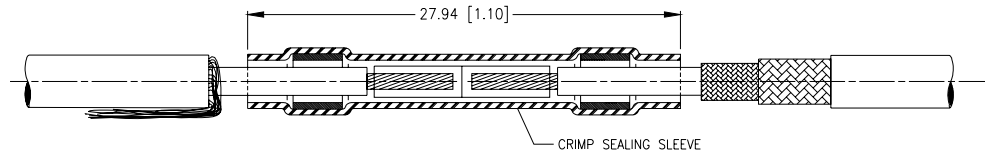
1. Place the Cable Sealing Sleeve, Flexible SolderShield and Crimp Sealing Sleeve on the cable attached to connector.
2. Strip cables as shown below.



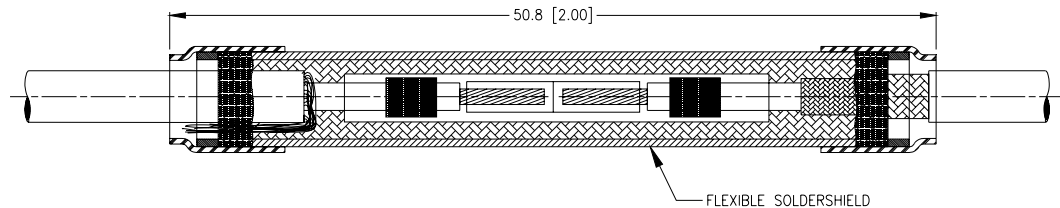
3. Crimp cable conductor onto metal Crimp barrel.



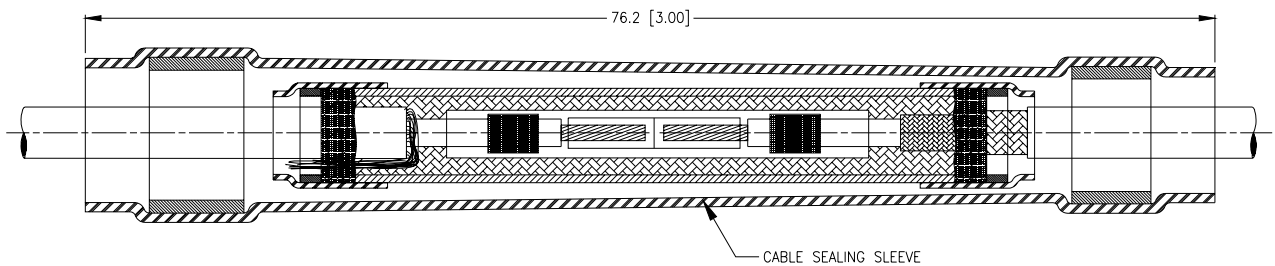
4. Install Crimp Sealing Sleeve on crimp barrel.



5. On the single shield side, fold the shields back to jacket with all strands grouped together.
6. Install the Flexible SolderShield as shown.



7. Install the Cable Sealing Sleeve as shown.



Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]

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